Patent Claims

1. A process for producing consumable products having an outer shell (1) made from a substance (10) which is introduced into a mold (4), into which a temperature-controlled ram (3.1 to 3.4) then moves, characterized in that the substance (10) is placed under pressure after the ram (3.1 to 3.4) has moved in.

2. The process as claimed in claim 1, characterized in that a displacement ram (7) is moved into the substance (10).

3. The process as claimed in claim 1 or 2, characterized in that a gas (21) is applied to the substance (10).

4. The process as claimed in one of claims 1 to 3, characterized in that a higher internal pressure is applied to an at least partially elastic ram (3.3, 3.4) after it has moved in.

5. An apparatus for carrying out the process as claimed in at least one of claims 1-4, characterized in that a displacement ram (7) is guided inside the ram (3.1).

6. The apparatus as claimed in claim 5, characterized in that the ram (3.1) has an axial bore (6) in which the displacement ram (7) is guided.

7. The apparatus as claimed in claim 6, characterized in that in the starting position the displacement ram (7) is retracted slightly into the axial bore (6).

8. An apparatus for carrying out the process as claimed in at least one of claims 1-4, characterized in that at least one tube (15), bore or the like, which is in communication with a gas connection 21, passes through the ram (3.2).

9. An apparatus for carrying out the process as claimed in at least one of claims 1-4, characterized in that the ram (3.3, 3.4) is designed to be at least partially elastic and surrounds an interior space (18) to which a pressure medium can be applied.

10. The apparatus as claimed in claim 9, characterized in that the pressure medium is simultaneously a cooling medium.

11. The apparatus as claimed in claim 9 or 10, characterized in that the ram (3.4) has an opening, preferably in the vertex region, which is covered by a diaphragm (23).

12. The apparatus as claimed in claim 11, characterized in that in the starting position of the ram (3.4) the diaphragm (23) is curved inward, but curves outward when the pressure is increased.